



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3884-1
Job Sheet 168899



Part No: D3884-1

Job Qty: 12 ea

Part Name: Saddle, Inside LH



Part Weight: 0.1bs

Status: Scheduled

Priority: Medium

Job Created: 11/24/17

Job Tracking No:

Due Date: 12/15/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV C IPP RevA: New issue DD verified by:EC IPP REV:B 15.05.20 remove inside powdercoat DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	12/14/17	12/14/17	0.00	0.00	Start Up Machining		SBZ 17/12/19
100	CNC Vertical Machining	12 pcs	12/14/17	12/14/17	0.50	21.82	HAAS 1		SBZ 17/12/20 FK 17-12-21
110	QC	12 pcs	12/14/17	12/14/17	0.00	0.00	QC2		FK 17-12-21
120	QC	12 pcs	12/14/17	12/14/17	0.00	0.00	QC8		17-12-22
130	HandFinish	12 pcs	12/14/17	12/14/17	0.00	0.69	HandFinish1		2017-12-22
140	Powdercoat	12 pcs	12/15/17	12/15/17	0.00	0.50	Powdercoat1		3K 17-12-22
150	QC	12 pcs	12/15/17	12/15/17	0.00	0.00	QC3		27 DEC 2017
160	Packaging	12 pcs	12/15/17	12/15/17	0.00	0.00	Packaging3		
170	QC21-SA	12 Ea	12/15/17	12/15/17	0.00	0.00	QC21		51404

Part Op 100 - Program Batch No. _____ 1-Machine Step No 1 per Folio FA818 and inspect per attached Dimension Sheets
Descriptions: 2-Machine Step No 2 per Folio FA818 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA818
and inspect per Dimension Sheets
110 - Inspect on CMM as per folio CMMA004.
140 - ***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED
ON DWG (SEE NOTE 2)***

M 138467 START: 7:50 O.V. T: 320° FINISH: 8:10

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-017	12	1	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Inboard, LH	2.870Inches	+ 0.010 - 0.000	2.880 2.870	
2	Saddle, Inboard, LH	1.433Inches	+ 0.010 - 0.000	1.443 1.433	
3	Saddle, Inboard, LH	0.638Inches	+ 0.020 - 0.000	0.658 0.638	
4	Saddle, Inboard, LH	3.895Inches	+ 0.010 - 0.000	3.905 3.895	
5	Saddle, Inboard, LH	0.257Inches	+ 0.005 - 0.000	0.262 0.257	
6	Saddle, Inboard, LH	0.605Inches		0.625	

			+ 0.020	0.605
			- 0.000	
7	Saddle, Inboard, LH	1.120Inches	+ 0.010	1.130
			- 0.000	1.120
8	Saddle, Inboard, LH	2.245Inches	+ 0.010	2.255
			- 0.000	2.245
9	Saddle, Inboard, LH	2.000Inches	+ 0.020	2.020
			- 0.000	2.000
10	Saddle, Inboard, LH	0.140Inches	+ 0.035	0.175
			- 0.000	0.140
11	Saddle, Inboard, LH	1.265Inches	+ 0.020	1.285
			- 0.000	1.265
12	Saddle, Inboard, LH	0.115Inches	+ 0.020	0.135
			- 0.000	0.115
13	Saddle, Inboard, LH	0.240Inches	+ 0.020	0.260
			- 0.000	0.240
14	Saddle, Inboard, LH	0.110Inches	+ 0.030	0.140
			- 0.000	0.110
15	Saddle, Inboard, LH	0.240Inches	+ 0.020	0.260
			- 0.000	0.240
16	Saddle, Inboard, LH	2.826Inches	+ 0.060	2.886
			- 0.000	2.826
17	Saddle, Inboard, LH	0.178Inches	+ 0.020	0.198
			- 0.000	0.178
18	Saddle, Inboard, LH	0.140Inches	+ 0.025	0.165
			- 0.000	0.140
19	Saddle, Inboard, LH	0.720Inches	+ 0.060	0.780
			- 0.000	0.720
20	Saddle, Inboard, LH	1.220Inches	+ 0.060	1.280
			- 0.000	1.220
21	Saddle, Inboard, LH	1.245Inches	+ 0.010	1.255
			- 0.000	1.245
22	Saddle, Inboard, LH	5.990Inches	+ 0.020	6.010
			- 0.000	5.990
23	Saddle, Inboard, LH	2.495Inches	+ 0.010	2.505
			- 0.000	2.495
24	Saddle, Inboard, LH	0.490Inches	+ 0.020	0.510
			- 0.000	0.490
25	Saddle, Inboard, LH	0.020Inches	+ 0.020	0.040
			- 0.000	0.020
26	Saddle, Inboard, LH	0.313Inches	+ 0.005	0.318
			- 0.000	0.313
27	Saddle, Inboard, LH	0.760Inches	+ 0.005	0.765
			- 0.000	0.760
28	Saddle, Inboard, LH	0.215Inches	+ 0.005	0.220
			- 0.000	0.215
29	Saddle, Inboard, LH	0.316Inches	+ 0.005	0.321
			- 0.000	0.316
30	Saddle, Inboard, LH	1.745Inches	+ 0.010	1.755
			- 0.000	1.745
31	Saddle, Inboard, LH	0.990Inches	+ 0.020	1.010
			- 0.000	0.990

Plex 11/24/17 11:05 AM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

DART AEROSPACE LTD		Work Order:	168899
Description: Saddle, Inboard, LH		Part Number:	D3884-1
Inspection Dwg: D3884	Rev: C	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875	SBL	17/12/20
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.649	.649	.650	.649		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.257	.257	.257	.257		
F	0.605	0.625		.613	.615	.616	.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.003	2.000	2.000	2.000		
J	0.140	0.175		.150	.150	.148	.150		
K	1.265	1.285		1.267	1.265	1.265	1.265		
L	0.115	0.135		.123	.123	.124	.122		
M	0.240	0.260		.248	.247	.248	.247		
N	0.110	0.140		.140	.135	.135	.135		
O	0.240	0.260		.249	.253	.252	.254		
P	2.826	2.886		2.855	2.856	2.856	2.856		
Q	0.178	0.198		.188	.188	.188	.188		
R	0.140	0.165		.153	.153	.153	.152		
S	0.720	0.780		.765	.763	.755	.765		
T	1.220	1.280		1.260	1.250	1.250	1.250		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.001	6.000	6.000	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		.500	.500	.500	.500		
Y	0.020	0.040		.030	.030	.030	.030		
Z	0.313	0.318		.313	.313	.313	.313		
AA	0.760	0.765		.760	.760	.760	.760		
AB	0.215	0.220		.217	.218	.218	.218		
AC	0.316	0.321		.316	.316	.316	.316		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.000	1.000	1.000	1.000		
AF									
Accept/Reject				✓	✓	✓	✓		

Measured by: SBL	me	FK	DAS
Date: 17/12/20	17-12-21		20
			9-89
			17-12-22

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 168 899
Description: Saddle, Inboard, LH		Part Number: D3884-1
Inspection Dwg: D3884	Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.649	.649	.650	.649		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.257	.257	.257	.257		
F	0.605	0.625		.615	.615	.615	.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.175		.152	.152	.154	.152		
K	1.265	1.285		1.265	1.265	1.265	1.265		
L	0.115	0.135		.124	.122	.124	.124		
M	0.240	0.260		.249	.248	.249	.249		
N	0.110	0.140		.135	.135	.135	.135		
O	0.240	0.260		.254	.256	.254	.254		
P	2.826	2.886		2.857	2.857	2.857	2.857		
Q	0.178	0.198		.188	.188	.188	.188		
R	0.140	0.165		.151	.153	.154	.153		
S	0.720	0.780		.765	.765	.765	.765		
T	1.220	1.280		1.250	1.250	1.250	1.250		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.000	6.000	6.000	6.001		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		.500	.500	.499	.501		
Y	0.020	0.040		.030	.030	.030	.030		
Z	0.313	0.318		.313	.313	.313	.313		
AA	0.760	0.765		.760	.760	.760	.760		
AB	0.215	0.220		.218	.218	.218	.218		
AC	0.316	0.321		.316	.316	.316	.316		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.000	1.000	1.000	1.000		
AF									
Accept/Reject				✓	✓	✓	✓		

Measured by: FK	Audited by: DAE
Date: 17-12-21	Date: 17-12-22

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 168899
Description: Saddle, Inboard, LH		Part Number: D3884-1
Inspection Dwg: D3884	Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9 7	10 2	11 3	12 4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.650	.650	.649	.649		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.257	.257	.257	.257		
F	0.605	0.625		.615	.615	.615	.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.175		.150	.151	.150	.148		
K	1.265	1.285		1.265	1.265	1.265	1.265		
L	0.115	0.135		.124	.124	.124	.124		
M	0.240	0.260		.248	.249	.249	.249		
N	0.110	0.140		.135	.135	.135	.135		
O	0.240	0.260		.254	.255	.254	.252		
P	2.826	2.886		2.857	2.857	2.857	2.857		
Q	0.178	0.198		.188	.188	.188	.188		
R	0.140	0.165		.153	.152	.152	.153		
S	0.720	0.780		.765	.765	.765	.765		
T	1.220	1.280		1.250	1.250	1.250	1.250		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.000	6.001	6.000	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		.501	.501	.500	.500		
Y	0.020	0.040		.030	.030	.030	.030		
Z	0.313	0.318		.313	.313	.313	.313		
AA	0.760	0.765		.760	.760	.760	.760		
AB	0.215	0.220		.218	.218	.218	.218		
AC	0.316	0.321		.316	.316	.316	.316		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.000	1.001	.999	1.000		
AF									
Accept/Reject				✓	✓	✓	✓	DAS	

Measured by:	FK
Date:	17-12-21

Audited by:	20
Date:	17-12-22

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	